

# Work Order ID 66605

Tuesday, February 22, 2011 1:59:12 PM



# PRELIMINARY ISSUE

Page 1

Item ID: D4334-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Swivel

Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 2.00



Customer:



Reference:

*Handwritten: 11.02.22*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4334

*Handwritten: PA3*

*Handwritten: PA4*

*Handwritten: 11.02.22*

100

0.00



Lathe Conv

Conventional Lathe

Memo

TURN AS PER DWG  
DWG REV: *Handwritten: PA4*

0.00

*Handwritten: 11.02.24*

*Handwritten: 2*

*Handwritten: Ø*

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*Handwritten: 11.02.24*




*Handwritten: 2*



*Handwritten: Ø*




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Item ID:	D4334-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Swivel					
Start Date:	2/23/2011	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/25/2011	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Mill Conv Conventional Milling Machine	Memo MILL AS PER DWG DWG REV: <i>PAY</i> DEBURR	0.00  0.00				<i>2</i>	<i>Ø</i>		
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00				<i>2</i>	<i>Ø</i>		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<i>2</i>	<i>Ø</i>		

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Item ID: D4334-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Swivel

Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 11-2-24

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 11 02 24 (2)

170

Identify as per dwg & Stock Location: *Pack* 0.00

Packaging

Memo

0.00


Packaging



2 *Q* *Final* 11-03-01  
*Pack* *2-4/3/01*


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Item ID: D4334-1 Accept  Setup Start   
Revision ID: PRELIM Stop   
Item Name: Swivel  
Start Date: 2/23/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 2/25/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

CD11103101

RD1370 MAR

POSITIVE RECALL  
EFFECTIVE 1/12/22 AUTH W  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

# Picklist Print

Tuesday, February 22, 2011 1:59:08 PM

Page 1

Work Order ID: 66605



Parent Item: D4334-1



Parent Item Name: Swivel

Start Date: 2/23/2011

Required Date: 2/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	50.4821	0.125	0.263158			



6061-T6 Round Bar 1.250

Location

MAT013

Loc Qty

50.48205

Loc Code

113457

31.48205

113550

19

263

Jan 11.02.23



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 66605
<b>Description:</b> <i>Swivel</i>		<b>Part Number:</b> D4334-1
<b>Inspection Dwg:</b> D4334 <b>Rev:</b> PA4		Page 1 of 1

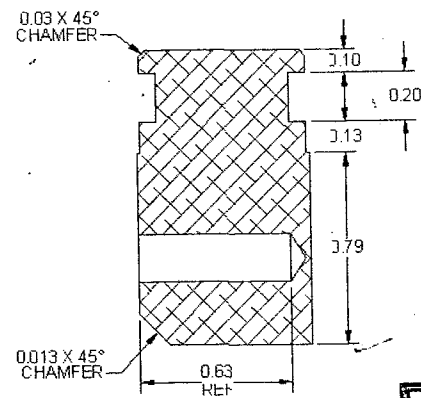
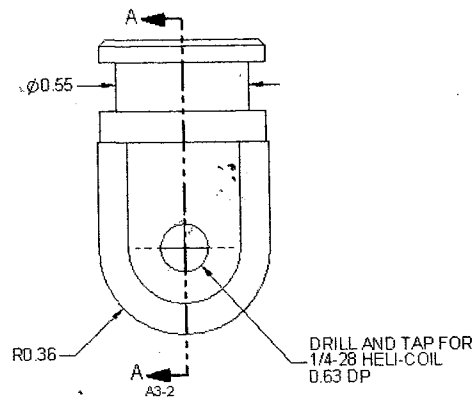
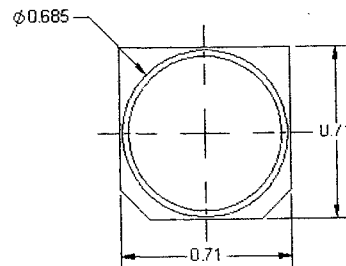
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.685	+/-0.10.	Ø.684	✓			
.71	+/-0.30	.707	✓			
.71	+/-0.30.	.717	✓			
Ø.55	+/-0.30	.552	✓			
R.36	+/-0.30	R.375	✓			
.63	+/-0.30.	.600	✓			
.03 x .45°	+/-0.30	.032 x .45°	✓			
.10	+/-0.30	.101	✓			
.20	+/-0.30	.199	✓			
.130	+/-0.30.	.125	✓			
.79	+/-0.30	.775	✓			

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> J.F.S.	<b>Preliminary Approval:</b>
<b>Date:</b> 11.02.24.	<b>Date:</b> 11/02/24	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Signature]* 10.04.15





SECTION A-A B6-2

**PRELIMINARY  
ISSUE**

**D4334-1 SWIVEL**

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 3.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4334	SHEET 2 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.02.10	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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